

Work Order ID 58834

Wednesday, May 19, 2010 1:08:20 PM



Page 1

Item ID: D3643-1

Accept



Setup Start



Revision ID:

Item Name: Stiffener

Stop



Start Date: 5/19/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 5/26/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10-5-19

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3643

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3643 ☒ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Deburr if necessary

2024 . 040

1B 10-6-2

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

1B 10-6-2

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

130

0.00



NC BRAKE

0.00

Brake NC

Memo

Brake NC

Form as per Dwg D3643

So 10/06/03

(8)

140

0.00



Small Fab

0.00

Small Fab

Memo

Small Fab

C'sink as per Dwg D3643

So 10/06/08 (8)

150

0.00



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

Quality Control

So 10/06/08

(8)

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Item ID: D3643-1

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Setup Start



Revision ID:

Item Name: Stiffener

Stop



Start Date: 5/19/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 5/26/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

8 BB 10-6-8

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10/06/08

8 BB

180

Identify as per dwg & Stock Location: 243 .

0.00



Packaging

Memo

0.00

Packaging

8 BB 10/06/08

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Work Order ID 58834

Wednesday, May 19, 2010 1:08:20 PM

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Item ID: D3643-1

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Item Name: Stiffener

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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/09 [Signature]
MF
10-6-9

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

Wednesday, May 19, 2010 1:08:25 PM

Page 1

Work Order ID: 58834



Parent Item: D3643-1



Parent Item Name: Stiffener

Start Date: 5/19/2010

Required Date: 5/26/2010

Comments: IPP Rev:A New Issue 07-07-20 JLM

Verified By:EC

Start Qty: 6.00

Required Qty: 6.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|---------------|----------------|--------|
| M2024T3S.040 | | Purchased | No | | | 100 | sf | 487.6000 | 0.1475 | 1.2 | | |



2024-T3 .040 sheet

18 10-6-2

Location

Loc Qty

Loc Code

MAT

96

114415

96

MAT22

391.6

110305

131.1

111786

15.5

112291

32

112331

64

113162

149

113162

⑧

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NOTE: Date & initial all entries

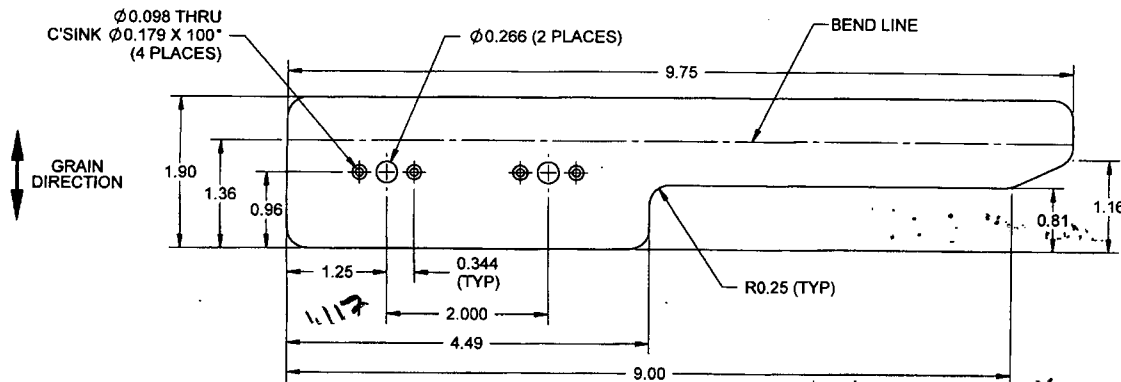
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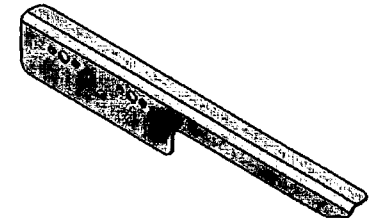
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NOTE: Date & initial all entries



D3643-1F FLAT PATTERN
(D3643-2F OPPOSITE)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58834



ENSURE THAT COUNTERSINKS
ARE ON THIS SIDE OF THE PART



D3643-1 STIFFENER (REPLACES GENEVA P/N G10610-2)
D3643-2 OPPOSITE (REPLACES GENEVA P/N G10610-1)

RELEASED
07.09.07

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3643-1/-2" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs

| | | | |
|--|----------------------------|----------------------|--------------|
| A | NEW ISSUE; REPLACES G10610 | LE | 07.07.27 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | DT | | |
| DRAWN | CE | | |
| CHECKED | BE | | |
| MFG. APPR. | BE | | |
| APPROVED | BE | | |
| DE APPR. | BE | | |
| DATE | 07.07.27 | | |
| DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | DRAWING NO. D3643 | REV. A |
| TITLE STIFFENER | | SCALE 2:3 | SHEET 1 OF 1 |
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